

Work Order ID 85300

June-05-12 3:31:51 PM

85300

Page 1

Item ID: D412-761-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Large Bubble Window, LH

Start Date: 05/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*Date: *12/06/05* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-761

Rev D

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D412-761-045 CHG001

*Sizbaltze**MLJ 12-6-22*

110

0.00

110

Pick Kit

Packaging

Memo

0.00

Packaging

12/6/22

120

0.00

120

QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*Sizbaltze**(12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85300

June-05-12 3:31:51 PM

85300

Page 2

Item ID: D412-761-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Large Bubble Window, LH

Start Date: 05/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-045								
	Location: _____								
	PPP Rev: <u>A</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF
12-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-05-12 3:31:56 PM

Page 1

Work Order ID: 85300

85300

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3704-3 *D3704-3* Escutcheon		Manufactured	No			110	Each	1.0000	0	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST075	1	
56880	1	

D412-761-043 *D412-761-043* Modified Latch Mechanism, LH		Manufactured	No			110	Each	2.0000	0	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST031A	2	
83022	2	

D3676-1 *D3676-1* Bubble Window, LH		Manufactured	No			110	Each	0.0000	0	1			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3678-1 *D3678-1* Placard		Manufactured	No			110	Each	9.0000	0	1			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST060	9	
46354	9	

D3678-3 *D3678-3* Placard		Manufactured	No			110	Each	8.0000	0	1			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST060	8	
46355	8	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-05-12 3:31:56 PM

Page 2

Work Order ID: 85300

85300

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3700-1
D3700-1
Inboard Window Doubler

Manufactured No 110 Each 3.0000

**

Location Loc Qty Loc Code

ST061 3
82783 3

Manufactured No 110 Each 0.0000

**

D3700-3
D3700-3
Outboard Window Doubler

Manufactured No 110 Each 3.0000

**

D3701-1
D3701-1
Floor Doubler

Location Loc Qty Loc Code

ST157 3
82784 3

Manufactured No 110 Each 2.0000

**

D3702-1
D3702-1
Fwd Doubler

Location Loc Qty Loc Code

ST196 2
54806 2

Manufactured No 110 Each 5.0000

**

D3703-1
D3703-1
Aft Doubler

Location Loc Qty Loc Code

ST196 5
56695 5

Manufactured No 110 Each 0.0000

**

D3703-3
D3703-3
Aft Corner Doubler

Shop Packet Print

June-05-12 3:31:56 PM

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-05-12 3:31:56 PM

Page 3

Work Order ID: 85300

Parent Item: D412-761-045

Parent Item Name: Large Bubble Window, LH

85300

D412-761-045

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3703-5

Manufactured No

110

Each

7.0000

D3703-5

Aft Cap

**

Location

Loc Qty

Loc Code

ST061

7

54809

7

Manufactured No

110

Each

5.0000

D3704-1

D3704-1

ESCUTCHEON

**

Location

Loc Qty

Loc Code

ST061

5

56696

5

Manufactured No

110

Each

3.0000

D3708-1

D3708-1

Angle

**

Location

Loc Qty

Loc Code

ST196

3

56697

3

Manufactured No

110

Each

3.0000

D3708-3

D3708-3

Angle

**

Location

Loc Qty

Loc Code

ST196

3

56698

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-05-12 3:31:56 PM

Page 4

Work Order ID: 85300

85300

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3709-1

Manufactured No

110

Each

14.0000

D3709-1

Angle

** 1 1

[Handwritten signature]

Location

Loc Qty

Loc Code

ST196

14

54814

7

56699

7

D3709-3

Manufactured No

110

Each

8.0000

D3709-3

Angle

** 56699 1

[Handwritten signature]

Location

Loc Qty

Loc Code

ST196

8

56700

8

D3802-1

Manufactured No

110

f

517.7500

13.5

13.5

D3802-1

Window Seal

** 56700

[Handwritten signature]

[Handwritten signature]

Location

Loc Qty

Loc Code

ST412

517.75

56881

0.75

81021

17

81868

500

1- Cut one per dwg d3802-1-135

DT9458

Manufactured No

110

Each

0.0000

1

1

DT9458

Cutting Template

** 51868

[Handwritten signature]

June-05-12 3:31:56 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-05-12 3:31:56 PM

Page 5

Work Order ID: 85300

Parent Item: D412-761-045

Parent Item Name: Large Bubble Window, LH

85300

D412-761-045

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-7A

Purchased

No

110

Each

131.0000

26

26

AN3-7A

Bolt

**

121444

Location

Loc Qty

Loc Code

ST351

131

117872

31

121444

100

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

52

52

AN960JD10

Washer

**

1121524

MS21042L3

Purchased

No

110

Each

2,146.0000

26

26

MS21042L3

Nut

**

121444

Location

Loc Qty

Loc Code

ST300

2146

115835

4

117885

32

119017

950

119075

138

121349

212

121444

810

MS24694-C5

Purchased

No

110

Each

63.0000

0

1

MS24694-C5

Screw

**

121444

Location

Loc Qty

Loc Code

ST289

63

106815

63

106815

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-05-12 3:31:56 PM

Page 6

Work Order ID: 85300

85300

Parent Item: D412-761-045

D412-761-045

Parent Item Name: Large Bubble Window, LH

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS24694-C13

Purchased

No

110

Each

38.0000

1

1

MS24694-C13

Screw

**

Location

Loc Qty

Loc Code

ST289

38

108558

38

108558

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X	1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1				X	D412-761-049	ARMREST KIT, LH
	1				D3589-041	LATCH ASSEMBLY
	1				D3589-047	FORWARD GUIDE
	1				D3589-049	AFT GUIDE
	2				MS16997-22	SCREW
	2				AN960JD6L	WASHER
	2				MS21042L06	NUT
		1			D3676-1	LARGE BUBBLE WINDOW
		1			D3678-1	PLACARD
		1			D3678-3	PLACARD
		1			D3700-1	INBOARD WINDOW DOUBLER
		1			D3700-3	OUTBOARD WINDOW DOUBLER
		1			D3701-1	FLOOR DOUBLER
		1			D3702-1	FORWARD DOUBLER
		1			D3703-1	AFT DOUBLER
		1			D3703-3	AFT CORNER DOUBLER
		1			D3703-5	AFT CAP
		1			D3704-1	ESCUTCHEON
		1			D3704-3	ESCUTCHEON
		1			D3708-1	ANGLE
		1			D3708-3	ANGLE
		1			D3709-1	ANGLE
		1			D3709-3	ANGLE
		1			D3802-1-135	SEAL
		1			DT9458	CUTTING TEMPLATE
		26			AN3-7A	BOLT
		52			AN960JD10	WASHER
		26			MS21042L3	NUT
		1			MS24694-C5	SCREW (OR MS24694-S5)
		1			MS24694-C13	SCREW (OR MS24694-S13)
			1		D3705-041	INSTRUMENT PANEL ASSEMBLY
			1		D3705-043	* INSTRUMENT PANEL WELDMENT
			1		D3335-1	* SPRING
			1		D3705-5	* ACCESS PANEL
			1		D3706-5	* PIN
			2		D3707-3	* MOUNTING LUG
			4		AN526C1032R6	* SCREW
			1		AN960JD516	* WASHER
			1		MS171498	* SPRING SLOTTED PIN
			4		MS24693-C272	* SCREW (OR MS24693-S272)

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 9)

(CONTINUED FROM PAGE 8)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
			2		D3707-1	MOUNTING LUG
			1		D3790-1	INDEXING BLOCK
			1		D3867-1	CONNECTOR PLATE
			4		AN3-3A	BOLT
			6		AN526C1032R6	SCREW
			2		AN743-12	BRACKET
			6		AN960JD10L	WASHER
			6		MS21075L3	NUTPLATE (OR MS21073-3)
			4		MS24693-C272	SCREW (OR MS24693-S272)
			1		MS27039-1-17	SCREW
			1		MS27039-1-27	SCREW
			4		MS21042L3	NUT
			2		MS21919WDG8	CLAMP
				1	D3694-041	MOUNTING PLATE ASSEMBLY
				1	D3694-1	* KEYWAY
				1	D3694-3	* PROTECTIVE PLATE
				1	D3694-5	* MOUNTING PLATE
				1	AN526C1032R8	* SCREW
				5	AN960JD10	* WASHER
				4	MS21042L3	* NUT
				2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				1	MS24693-C271	* SCREW (OR MS24693-S271)
				4	MS24693-C273	* SCREW (OR MS24693-S273)
				1	D3695-041	SLIDER ASSEMBLY
				1	D3695-1	* SLIDER
				1	D3695-3	* STOPPER
				1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
				1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
				4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				4	MS24693-C276	* SCREW (OR MS24693-S276)
				1	D3780-041	ARMREST ASSEMBLY
				1	D3696-041	* ARM ASSEMBLY
				1	D3696-1	** ARM
				1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
				1	D3781-041	* LATERAL CUSHION ASSEMBLY
				1	D3781-043	* ARMREST CUSHION ASSEMBLY
				1	D3785-3	* BRACKET
				1	D3977-1	* BOLT
				1	D3978-1	* NUT (CASTELLATED)
				1	D3979-1	* WASHER (SQUARE HOLE)
				2	AN970-6	* WASHER
				1	MS24665-302	* COTTER PIN
				2	MS21042L3	* NUT
				2	MS24693-C272	* SCREW
				2	MS24693-C277	* SCREW
				1	NAS1149D0663J	* WASHER

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 10)

(CONTINUED FROM PAGE 9)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
				11	AN3-6A	BOLT
				1	AN6-26	BOLT
				1	AN310-6	CASTELLATED NUT
				11	AN960JD10	WASHER
				1	AN960JD616L	WASHER
				2	NAS1515H6L	WASHER
				1	MS24665-302	COTTER PIN
				3	MS21071L3	ANCHORNUT
				8	MS21075L3	NUTPLATE

6.0 PARTS LIST, OPTIONAL VENT KIT

QTY -141	PART NUMBER	DESCRIPTION
X	D412-761-141	VENT KIT
4	D3932-1	SNAP VENT

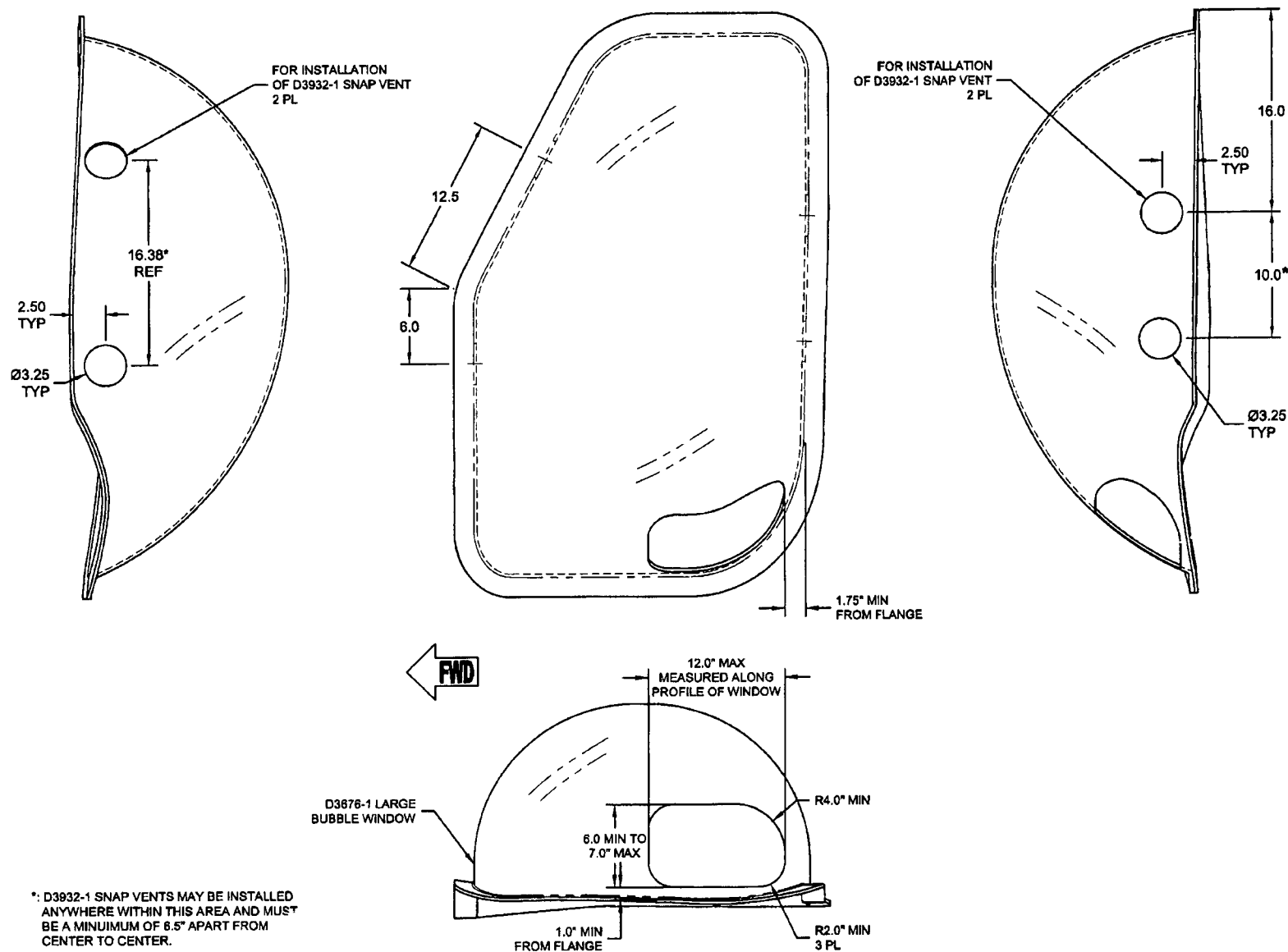


Figure 3 – Acceptable Cutouts in D3676-1 Large Bubble Window

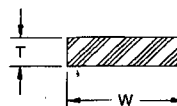
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

• COPYRIGHT © 2008 BY DART AEROSPACE LTD. •

Revision: D

Date: 09.06.18

SPECIFICATION CONTROL DRAWING



D3802-X-YYY WINDOW SEAL WHERE YYY REPRESENTS LENGTH

DART P/N	SUPPLIER	SUPPLIER P/N	T THICKNESS	W WIDTH
D3802-1-YYY	McMASTER-CARR	93695K58	0.25	1.00

EG: 0.25" X 1.00" X 40" WINDOW SEAL = D3802-1-040
0.25" X 1.00" X 120" WINDOW SEAL = D3802-1-120

RELEASED
2011-11-25

- NOTES:
- 1) MATERIAL: 'PEEL AND STICK' NEOPRENE/EPT/SBR BLEND CLOSED CELL SPONGE, MEDIUM DENSITY
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

D	CORRECTED P/N EXAMPLE FOR CUT LENGTH OF 40"; ADDED EXAMPLE FOR CUT LENGTH OF 120" (ZIN B3-1); REASON: PAR11-100.	MB	11.11.22
C	CHANGE SUPPLIER P/N TO 93695K58 PER FLAMMABILITY TEST RESULTS	MB	10.08.30
B	CHANGE SUPPLIER P/N TO 93695K88 PER FLAMMABILITY TEST RESULTS	MB	08.12.16
A	NEW ISSUE	MB	08.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.11.22		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3802 REV. D SHEET 1 OF 1 TITLE WINDOW SEAL SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			